

Date: Monday, 13/04/2009 8:22:27 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END CAP
Job Number	: 47114		
Estimate Number	: 11675		
P.O. Number	:	Part Number	: D28502
This Issue	: 13/04/2009 S.O. No. :	Drawing Number	: D2850 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 31409	Material	:
Written By	:	Due Date	: 28/04/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 09.04.13</u>		
Comment	: Est. B 98.12.07 Changed folio DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B2500X01500	6061-T6 Bar 2.50 x 1.50
-----	--------------------	-------------------------



Comment: Qty.: 0.3368 f(s)/Unit Total: 3.3684 f(s)

6061-T6 Bar 2.5" x 1.5"

6061-T6 2.5" X 1.5"

Batch M100947

09/04/15 (10)

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Shear blanks: 3.8"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2850-2

Deburr and Tumble

N.A 09/04/16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 09/04/16

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

ms/197
09/04/17

6.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PATE

09/04/20 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 13/04/2009 8:22:27 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 47114

Part Number: D28502

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
2009/04/20

Job Completion



U 09.04.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 27114
Description: High Float Step End Bracket		Part Number: D2850-2
Inspection Dwg: D2850 Rev: A		Page 1 of 1

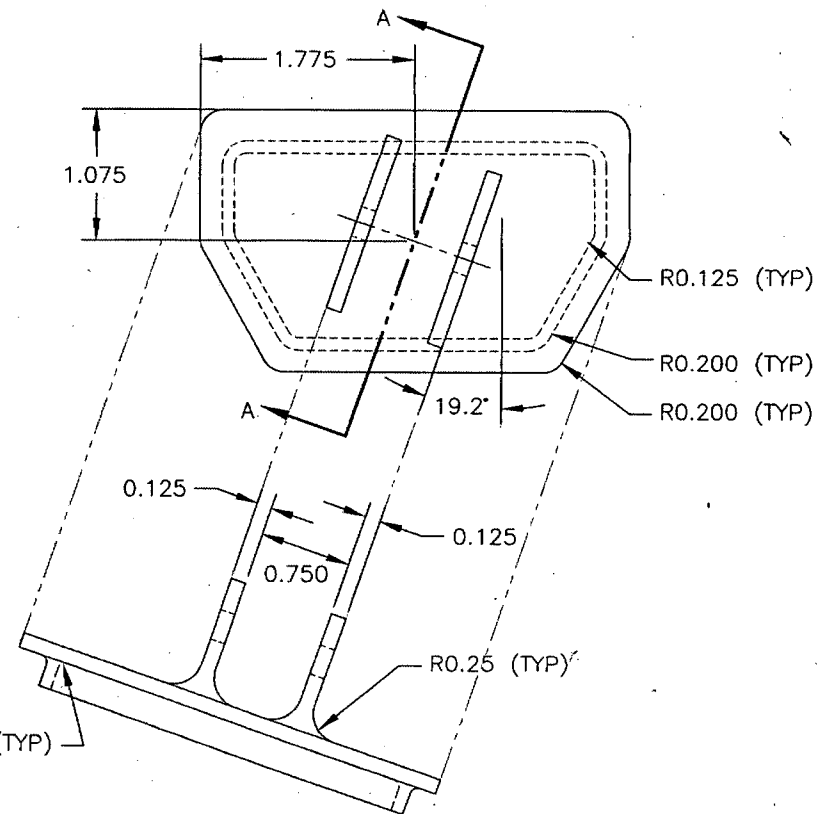
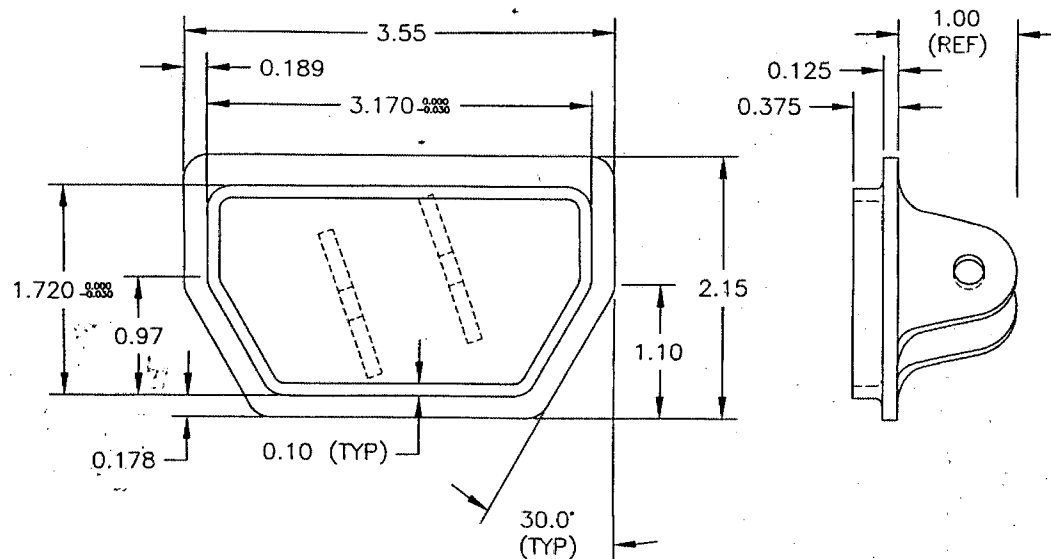
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.55	+/-0.030	3.551	✓			
0.189	+/-0.010	0.197	✓			
1.720	+0.000/-0.030	1.720	✓			
0.178	+/-0.010	0.171	✓			
0.10	+/-0.030	0.103	✓			
30°	+/-0.5°	30°	✓			
2.15	+/-0.030	2.153	✓			
0.375	+/-0.010	0.370	✓			
0.125	+/-0.010	0.120	✓			
1.00	+/-0.030	0.999	✓			
0.125	+/-0.010	0.135	✓			
0.750	+/-0.010	0.750	✓			
R0.25	+/-0.030	R0.250	✓			
R0.063	+/-0.010	R0.063	✓			
Ø0.257	+0.006/-0.001	Ø0.259	✓			
0.600	+/-0.010	0.6025	✓			

Measured by: K.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/04/16	Date: 09/04/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	[Signature]



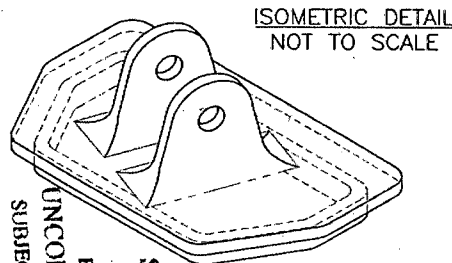
D2850-1 (SHOWN)
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

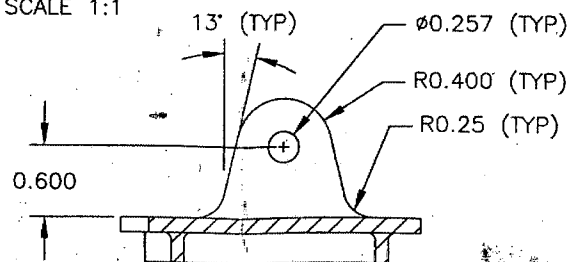
FINISH: NONE

BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



SECTION A-A
SCALE 1:1



RELEASED
95/125 KE
COPY ISSUED

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN CP	DRAWN BY CP	DART DART AEROSPACE LTD WARRICKSBURY, OXFORD, ENGLAND	
CHECKED KE	APPROVED ##	DRAWING NO. D2850	REV. A SHEET 1 OF 1
DATE 98.11.10	TITLE HIGH FLOAT STEP END BRACKET		SCALE 1:1

Copyright 1998 by DART AEROSPACE LTD

NO. 1111
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER